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S148876

D3488-3

Job Sheet 187882-A



Part No: D3488-3

Job Qty: 1 pcs

Part Name: Blade Fitting, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 1/4/19

Created By: Jason Leroux

Type: SOLD

Description:

Note: DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	QC 2	1 pcs		1/4/19	0.00	0.00	QC 2 - 1		
120	HAAS 4 Axis - B4B	1 pcs		1/4/19	0.11	0.69	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/01/30
							HAAS - 4 - B4B		
130	QC 2	1 pcs		1/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		SBL 19/01/30

140 QC 8	1 pcs	1/4/19	0.00 0.00	QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 8 - 12	mk 19/01/30
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
150 Handfinish - 1-1 Chemical- B4B	1 pcs	1/4/19	0.00 0.03	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/01/30
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White Gl(A)- B4B	1 pcs	1/4/19	0.00 0.04	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BEB 19-01-30
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	

170 QC 3	1 pcs	1/4/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	HL 19-1-30
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 26	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 38	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 6	
				QC 3 - 68	
				QC 3 - 9	
200 Packaging 3-1 - Stock - B4B	1 pcs	1/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-001 HL 19-1-30
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG
210 QC 21 - SA	1 pcs	1/4/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	9-31 JAN 30 2019

Part Op 110 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)

Descriptions: 120 - HAAS1-3 (HAAS CNC Vertical Machine) 1-Machine as per Folio FA627 & Dwg D3488

130 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB)

140 - QC8 Machining-2 (QC8- Inspect parts - second check)

150 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)

160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 10:20 OVEN TEMPERATURE:M138997. 320° FINISH TIME: 10:50

170 - QC3 (QC3- Inspect Part Finish)

200 - Packaging3-1 (Identify as per dwg & Stock Location: _____ LOCATION : FP001

210 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 1/29/19 8:35 AM dart.leroux.jason

157882-A
~~157882~~

DART AEROSPACE LTD		Work Order:	
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number:	D3488-1-3
Inspection Dwg: D3488 / DSK101 Rev: C / D		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.151				
Ø2.780	+/-0.005	2.779				
Ø3.125	+/-0.010	3.124				
Ø3.346	+/-0.010	3.347				
0.125 x 45°	+/-0.010 x +/-0.1°	0.120 x 45°				
8.000	+0.030/-0.000	8.010				inside Hole
9.250	+/-0.010	9.251				
0.188	+/-0.010	0.188				
R0.032	+/-0.010	R0.032				
R0.062	+/-0.010	R0.062				
Ø0.297	+0.005/-0.001	X				
Ø0.430	+/-0.010					
Ø0.100	+/-0.010					
0.200	+/-0.010	0.198				
2.620	+/-0.010	2.618				
3.500	+/-0.010	X				
1.005	+/-0.010					
Ø0.484	+0.005/-0.001	0.486				
1.180	+/-0.010	1.180				
3.150	+/-0.010	3.150				
3.070	+/-0.010	3.066				
R0.063	+/-0.010	R0.063				

187882-A

187882

DART AEROSPACE LTD		Work Order:	187882
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number:	D3488-3
Inspection Dwg: D3488 / DSK101 Rev: C / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.508	✓		PC	
0.750	+/-0.010	.750	✓		Vern	
1.500	+/-0.010	1.500	✓		Vern	
11.18	+/-0.030	11.183	✓		HG	
R0.062	+/-0.010	.062	✓		RC	
0.125	+/-0.010	.127	✓		Vern	
0.590	+/-0.010	.590	✓		Vern	
0.793	+/-0.010	.798	✓		HG	
1.351	+/-0.010	1.357	✓		HG	
1.317	+/-0.010	1.322	✓		Vern	
1.802	+/-0.010	1.807	✓		HG	

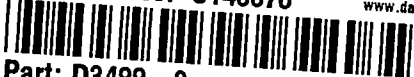
Measured by: <i>DE SBC</i>	Audited by: <i>mf</i>	Prototype Approval:	N/A
Date: 19/01/25	Date: 19/01/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	
D	18.11.21	Dimension 0.125 changed to 0.200	MG	<i>M</i>

DART
AEROSPACE

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Container No: S148876



Part: D3488-3

Job No: 187882-A

Serial No/Batch: S148053

Revision: D/C

Inspector:

Exp Date:

Instructions:

Date: 01/30/19